



# SS 317 L

## STAINLESS STEEL ELECTRODE

**CLASSIFICATION :**

**IS : 5206-83 : E 19.12 3LR26**  
**AWS/A 5.4 : E 317L-16**

**CHARACTERISTICS :**

A stainless steel electrode which yields a weld deposit with extra low carbon and controlled ferrite content of 2 to 8 FN. Weld deposit has good resistance to intergranular corrosion and creep resistance. Suitable for welding in all conventional positions and operates equally well on AC and DC(+).

**APPLICATIONS :**

- \* Welding of low carbon, molybdenum bearing austenitic stainless steels like AISI 317L and equivalent grades.
- \* Useful in severe corrosion applications.

**RECOMMENDATIONS :**

Re-dry the electrodes at 200°C for one hour before use. Use low current, short arc and stringer bead technique. Maintain interpass temperature 150°C max.

**CHEMICAL ANALYSIS OF WELD-METAL(%) (TYPICAL) :**

C	Mn	Si	Cr	Ni	Mo	S	P
0.04	0.5-2.5	1.0	18-21	12-14	3-4	0.03	0.04
max		max				max	max

**MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) (TYPICAL) :**

Ultimate Tensile Strength N/mm <sup>2</sup>	Elongation (GL=4d) (%)
520 min	30 min

**CURRENT CONDITIONS : USE AC OR DC (+)**

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

**SPECIAL CHARACTERISTICS :**

**DELTA FERRITE :** 3 to 8 FN



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